

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76099

**\*76099\***

Page 2

November-07-11 7:58:01 AM

Item ID: D3622-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ball Stud  
 Start Date: 07/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 21/11/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten notes and signatures:*  
 11/11/23 (202)  
 11/11/23  
 ME  
 11-11-23

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# Picklist Print

November-07-11 7:58:05 AM

Page 1

Work Order ID: 76099

\*76099\*

Parent Item: D3622-1

\*D3622-1\*

Parent Item Name: Ball Stud

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303H0.500

Purchased

No

100

f

55.8795

0.108

2.273684

\*M303H0 500\*

\*\*

33.500'

17 11/11/22

303 HEX BAR .500

Location

Loc Qty

Loc Code

MAT037

55.8795

109778

55.8795

33.500'

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76099
<b>Description:</b> Ball Stud		<b>Part Number:</b>	D3622-1
<b>Inspection Dwg:</b> D3622	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	0.563	✓		SLC8 SLC2	
0.50	+/-0.030	0.500	✓		"	
Ø0.394	+/-0.010	Ø0.391	✓		"	
Ø0.310	+/-0.010	Ø0.307	✓		"	
Ø0.215	+/-0.010	Ø0.212	✓		"	
0.155	+/-0.010	0.160	✓		"	
0.313	+/-0.010	0.313	✓		"	
0.478	+/-0.010	0.476	✓		"	
0.630	+/-0.010	0.633	✓		"	
0.125	+/-0.010	0.120	✓		"	
0.563	+/-0.010	0.562	✓		"	
1.19	+/-0.030	1.188	✓		"	
0.3125-24UNF-3A	+0.000/-0.072	0.312-24	✓		"	
M.O.W.	Min = 0.3336 Max = 0.3363	0.335	✓		"	

<b>Measured by:</b>	ST Long
<b>Date:</b>	11/11/22

<b>Audited by:</b>	X
<b>Date:</b>	11-11-23

<b>Preliminary Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	

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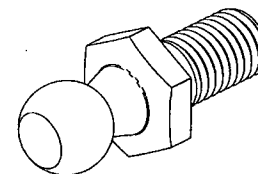
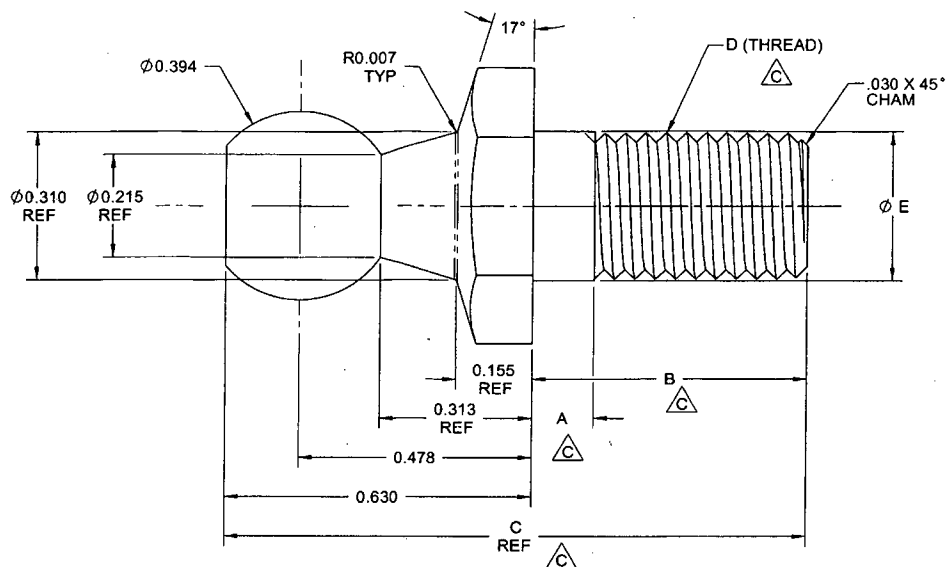
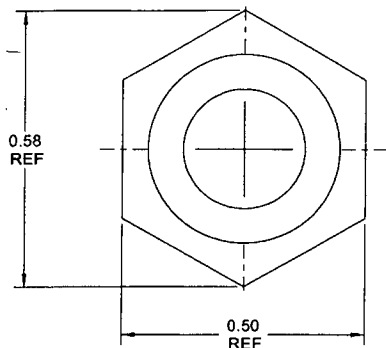
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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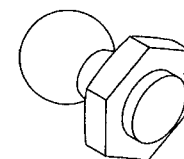
**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D3622-1 BALL STUD  
SHOWN**



**D3622-11 BALL STUD  
SHOWN**

**RELEASED**  
2010-09-23

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76099-M.C.J  
11/11/07

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840 0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270 0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053 0.3125

**D3622-X BALL STUD**

- NOTES:  
1) MATERIAL: AISI 303 HEX BAR  
REF DART SPEC M303H0.500  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044  
7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	D3622	
CHECKED		REV. C	
MFG. APPR.		SHEET 1 OF 1	
APPROVED		TITLE	
DE APPR.		BALL STUD	
DATE	10.07.20	SCALE NTS	

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8 7 6 5 4 3 2 1

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